

Date: Tuesday, 10/06/2008 3:14:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: "T" HANDLE ASSEMBLY
Job Number	: 39802		
Estimate Number	: 11179		
P.O. Number	:	Part Number	: D2282041
This Issue	: 10/06/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2282 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 38606A	Drawing Revision	: E
Written By	:	Material	:
Checked & Approved By	: <u>JLD 08 6-10</u>	Due Date	: 30/06/2008
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM	Qty:	50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22823	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-3	Handle tube	9X B35472
		41X B38640

(50)

EL 8-8-5

2.0	D22825	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-5	Handle tube	50X B38641

(50)

EL 8-8-5

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.as per dwg D2282

*****brush weld right after welding, to take color off *****

A/R	ER316L SS	Filling Rod	M101744
		Dwg Rev:	E

(50)

EL 8-8-6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 39802

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 0808-21 (50)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

5/10/12
Ball welded mark +
Tumble

08/08/12 50 thn

SB 08/08/21

(50)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/21 (10) counter

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

11

08.08.21 50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



mf 08-08-21

(30)

Dart Aerospace Ltd

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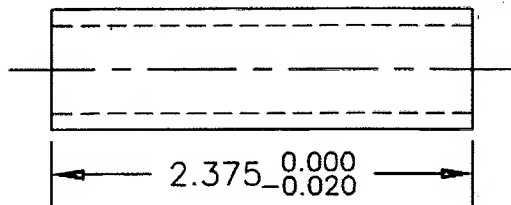
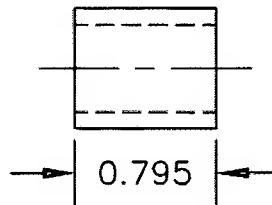
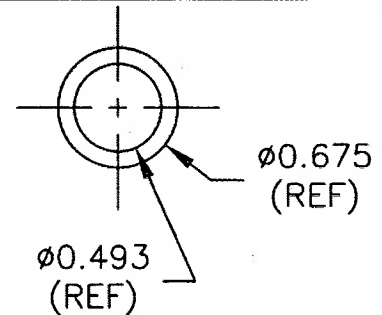
NOTE: Date & initial all entries

DART

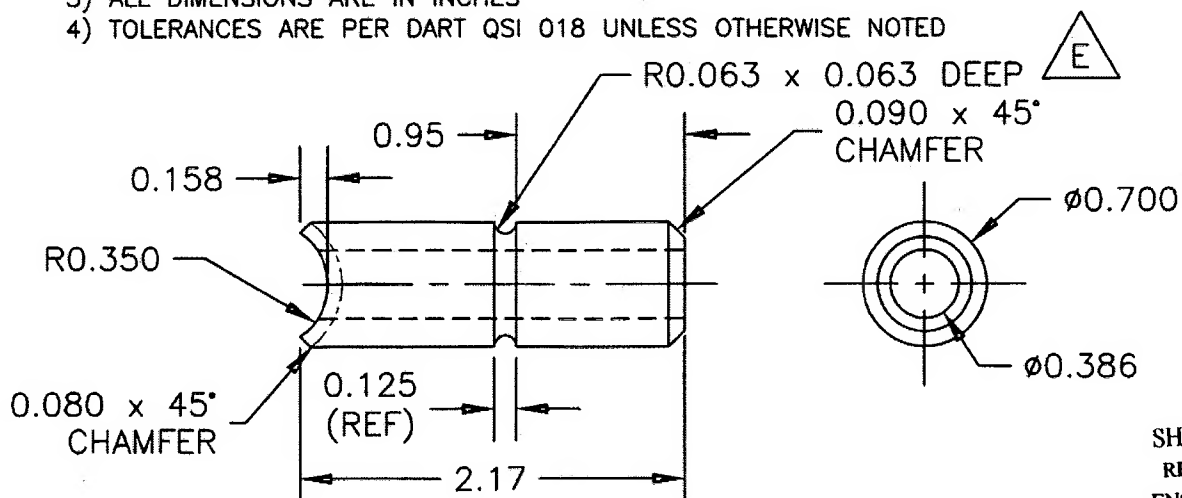
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



NO. 37802

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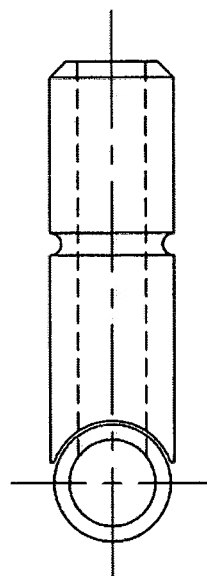
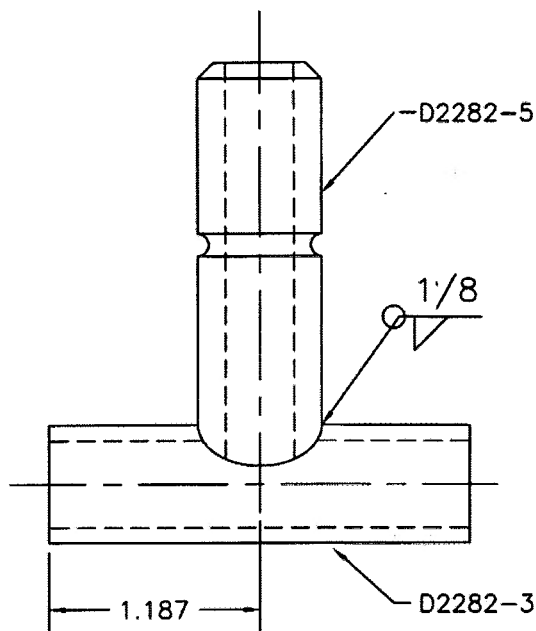
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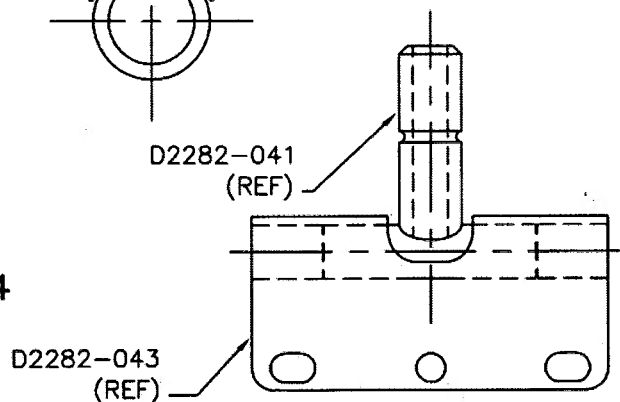
DART

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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

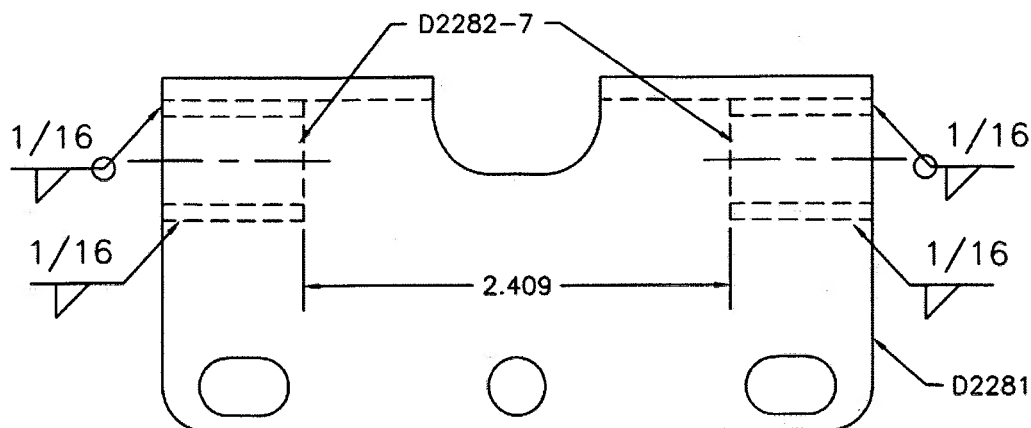


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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